

Work Order ID 66155-2

Monday, February 07, 2011 11:20:49 AM

Page 1

Item ID: D3278-041

Accept

Revision ID:

Item Name: Support Assembly

Start Date: 2/8/2011 Start Qty: 60.00

Required Date: 2/22/2011 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: MF

Date: 11-02-07 Tooling:

QC:

Date: SPC (Y/N):

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

ES 11/02/28 (35)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

ES 11/02/28

count (35)

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041

ES 11/03/01 (35)

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Item ID: D3278-041

Accept



Setup Start



Revision ID:

Item Name: Support Assembly

Stop



Start Date: 2/8/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/14

*counted
+35*

140

Identify as per dwg & Stock Location: *471*

0.00



Packaging

Memo

0.00

Packaging

11/3/12 (352) SP

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/03

*PL 11-03-2
35*

Picklist Print

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Work Order ID: 66155

Parent Item: D3278-041

Parent Item Name: Support Assembly



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: L A 04.04.19 New issue KJ/JLM
IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A



Bolt

Purchased

No

120

Each

682.0000

2

120



EP 5/11/03/01

Location

Loc Qty

Loc Code

ST357

682

116191

7

116669

375

116786

300

70

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

30.0000

4

240



Washer

4 M116805 (140)



EP 5/11/03/01

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

D2230-1



Lug

Manufactured

No

120

Each

61.0000

2

120



EP 5/11/03/01

Location

Loc Qty

Loc Code

ST476

61

64423

61

27

B65276

(43x)

Picklist Print

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Page 2

Work Order ID: 66155

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

D3278-1



Support

Manufactured No

100 Each

11.0000 1

60



Ep 5/11/02/28

B65074 (35x)

Location

Loc Qty

Loc Code

GE

4

62482

4

ST048

7

51353

7

D3278-2



Support

Manufactured No

100 Each

10.0000 1

60



Ep 5/11/02/28

B65075 (35x)

Location

Loc Qty

Loc Code

CA

7

62483

17

ST045

2

62022

2

ST048

1

60565

1

D3278-3



Spacer

Manufactured No

100 Each

69.0000 1

60



Ep 5/11/02/28

~~30~~ 30

~~5~~ 5

Location

Loc Qty

Loc Code

GA

55

65076

55

ST045

14

60244

14

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 66155

Parent Item: D3278-041

Parent Item Name: Support Assembly

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 60.00

Required Qty: 60.00

MS20426AD3-6

Purchased

No

120

Each

4,641.000

4

240



Rivet



ES 11/02/08

Location

Loc Qty

Loc Code

ST316

4641

105055

1071

116289

3570

140

MS21042L4

Purchased

No

100

Each

3,720.000

2

120



Nut



ES 11/03/01

Location

Loc Qty

Loc Code

ST300

3720

1123143

2

115589

10

115621

21

116188

3500

116548

187

35

Monday, February 07, 2011 11:20:47 AM

Shop Packet Print

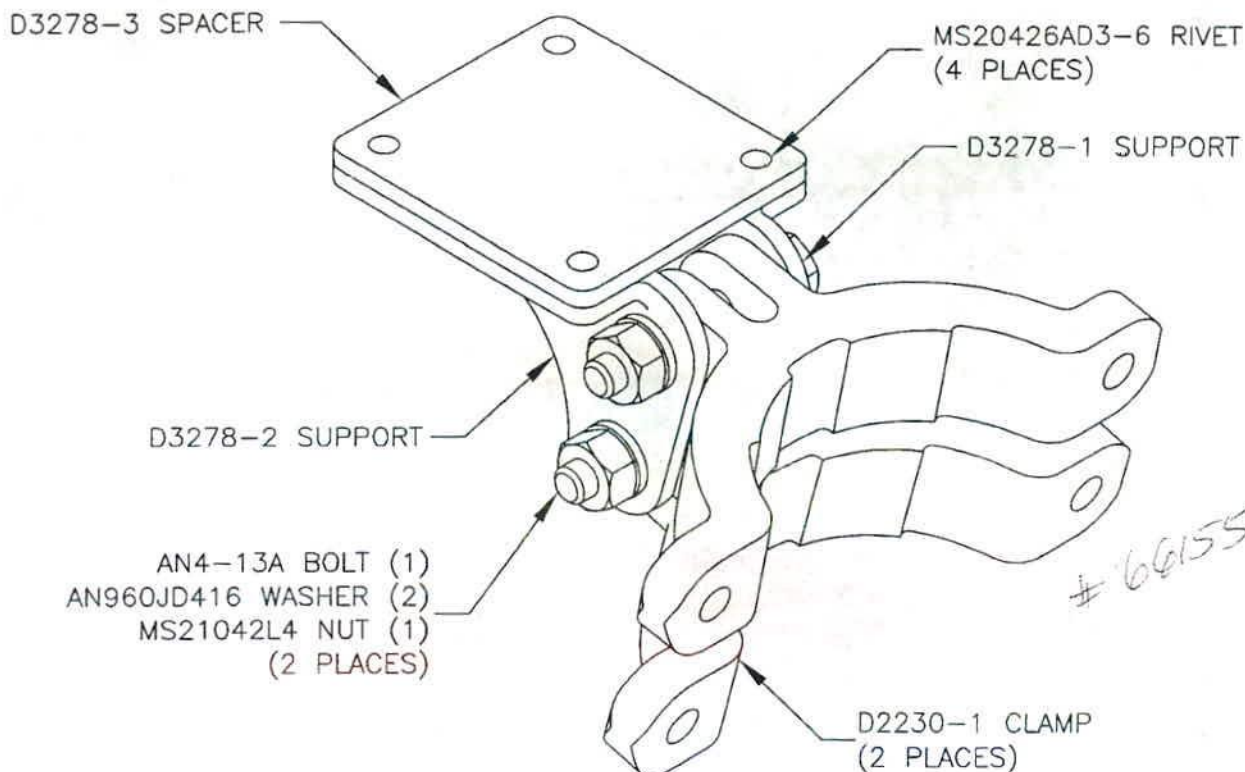
Page 3



DESIGN <i>97</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07 08 06

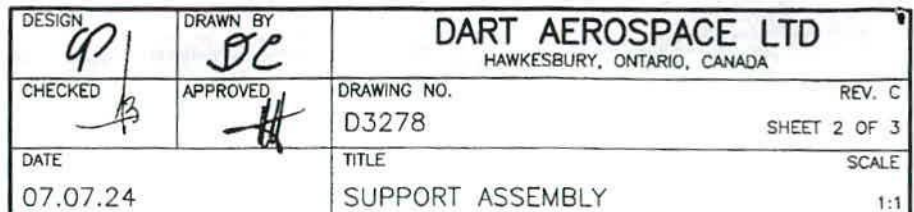
D3278-041 SUPPORT ASSEMBLY



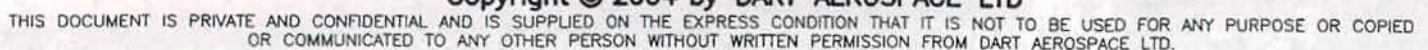
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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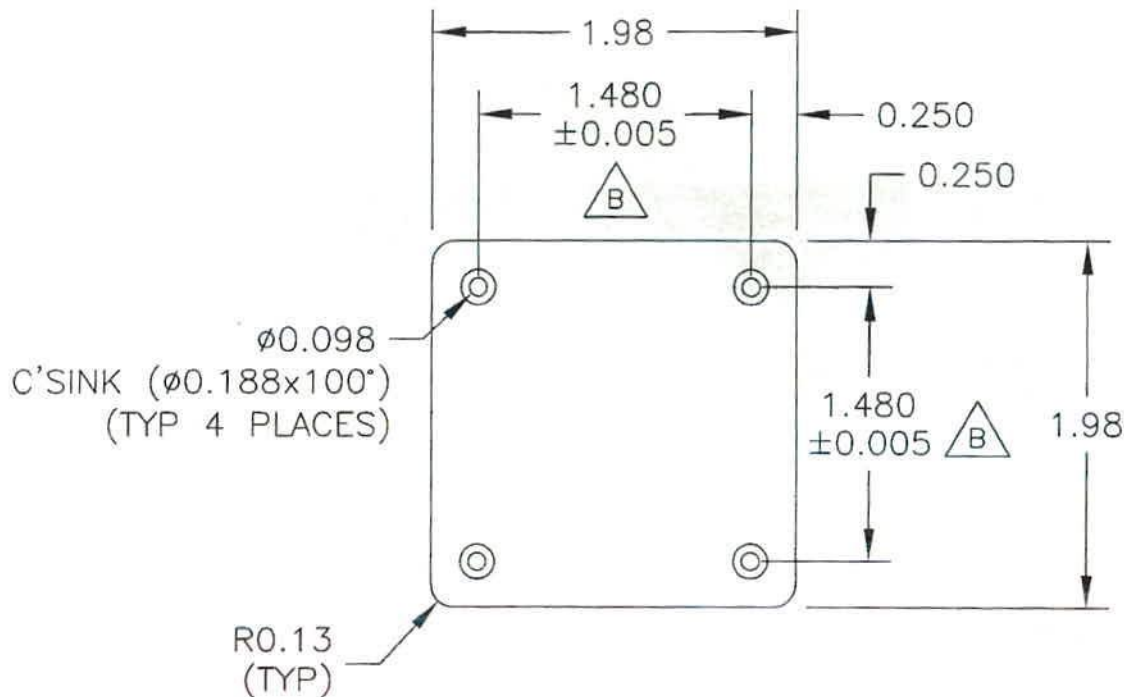


RELEASED
07-08-08



DART

DESIGN <i>qp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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